

Date: Wednesday, 12/5/2007 10:36:06 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206/OH-58 SADDLE, INBOARD, LEFT SIDE
 Job Number : 36143
 Estimate Number : 10836
 P.O. Number :
 This Issue : 12/5/2007 S.O. No. :
 Prsht Rev. : NC Part Number : D29391
 First Issue : // Type : MACHINED PARTS Drawing Number : D2939 REV C
 Drawing Revision : C
 Previous Run : 34632 Material :
 Due Date : 12/24/2007 Qty: 8 Um: Each
 Written By :
 Checked & Approved By : *07.12.05*
 Comment : Est: B 00.06.26 New DWG rev (mpp 2069) EC
 Est Rev: C As per Rev C 07-03-19 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101001 7075-T7351 2X6X6.25



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Issue material from stock: 7075-T7351 QQ-A-250/12

Cut Size 2.0 x 6.25 X 6.00

Grain Along Long 6.00 Length

Batch No: *B 34872*

DTP 08/04/03

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1.

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

5-Deburr

DTP 08/04/03

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

S.F 08/04/05

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

DTP 08/04/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/5/2007 10:36:06 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE

Job Number: 36143

Part Number: D29391

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

FL 08-04-07 (8)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 08/04/07 (8)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 107550

FL 08-04-07 (8)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M-FL

08/04/07 (8X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *430*

8/4/07

8-04-07

SD (8X)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/08

Job Completion



mf 08-04-07

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36143
Description: 206 Saddle, Inboard, Left side	Part Number:	D2939-1
Inspection Dwg: D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.131	0.131	0.131	0.131		
B	0.100	0.140		0.131	0.132	0.132	0.132		
C	0.100	0.140		0.126	0.128	0.126	0.126		
D	0.210	0.230		0.221	0.221	0.221	0.222		
E	1.245	1.255		1.247	1.249	1.248	1.249		
F	1.245	1.255		1.247	1.250	1.249	1.249		
G	2.495	2.505		2.501	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.576	1.576	1.576	1.577		
J	2.495	2.505		2.498	2.499	2.499	2.499		
K	0.257	0.262		0.259	0.259	0.259	0.259		
L	0.312	0.317		0.316	0.316	0.316	0.316		
M	0.235	0.240		.238	.235	.237	.237		
N	0.100	0.140		0.121	0.121	0.121	0.121		
O	0.540	0.560		0.551	0.552	0.554	0.554		
P	0.490	0.510		0.502	0.500	0.502	0.502		
Q	3.715	3.725		3.718	3.718	3.719	3.720		
R	2.720	2.760		2.738	2.739	2.739	2.738		
S	0.240	0.270		0.250	0.250	0.249	0.248		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	1.625	1.635		1.6295	1.630	1.630	1.629		
V	1.362	1.372		1.366	1.366	1.366	1.366		
W	0.316	0.321		0.321	0.321	0.321	0.321		
X	1.250	1.270		1.261	1.261	1.260	1.261		
Y	1.565	1.585	DT8695 A/B	1.576	1.576	1.575	1.576		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	DJP
Date:	08/04/03

Audited by:	[Signature]
Date:	08.04.03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	[Signature]

DART AEROSPACE LTD	Work Order:	36143
Description: 206 Saddle, Inboard, Left side	Part Number:	D2939-1
Inspection Dwg: D2939 Rev. C		Page 1 of 1

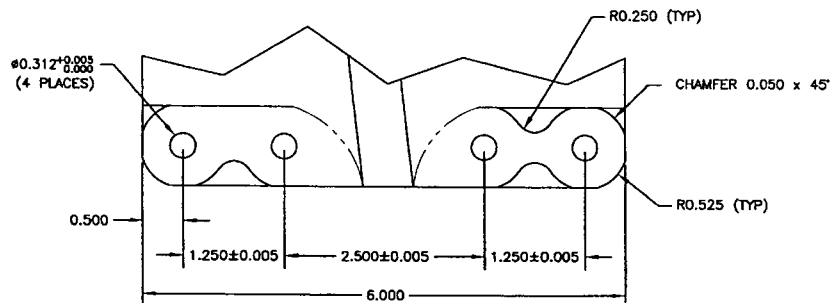
Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5	6	7	8		
A	0.100	0.140		0.131	0.131	0.131	0.131		
B	0.100	0.140		0.132	0.130	0.130	0.132		
C	0.100	0.140		0.130	0.130	0.129	0.128		
D	0.210	0.230		0.221	0.222	0.222	0.222		
E	1.245	1.255		1.248	1.248	1.249	1.249		
F	1.245	1.255		1.248	1.248	1.248	1.249		
G	2.495	2.505		2.501	2.500	2.500	2.499		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.576	1.577	1.577	1.5755		
J	2.495	2.505		2.500	2.500	2.500	2.498		
K	0.257	0.262		0.259	0.259	0.259	0.259		
L	0.312	0.317		0.316	0.316	0.3165	0.316		
M	0.235	0.240		.237	.237	.235	.238		
N	0.100	0.140		0.121	0.121	0.121	0.121		
O	0.540	0.560		0.552	0.552	0.549	0.551		
P	0.490	0.510		0.497	0.496	0.498	0.499		
Q	3.715	3.725		3.7195	3.719	3.720	3.719		
R	2.720	2.760		2.738	2.739	3.7375	3.740		
S	0.240	0.270		0.250	0.249	0.250	0.250		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	1.625	1.635		1.629	1.629	1.629	1.629		
V	1.362	1.372		1.366	1.366	1.367	1.365		
W	0.316	0.321		0.321	0.321	0.321	0.321		
X	1.250	1.270		1.2615	1.2605	1.2615	1.261		
Y	1.565	1.585	DT8695 A/B	1.577	1.576	1.577	1.576		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <u>DTJ</u>
Date: <u>08/04/04</u>

Audited by:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

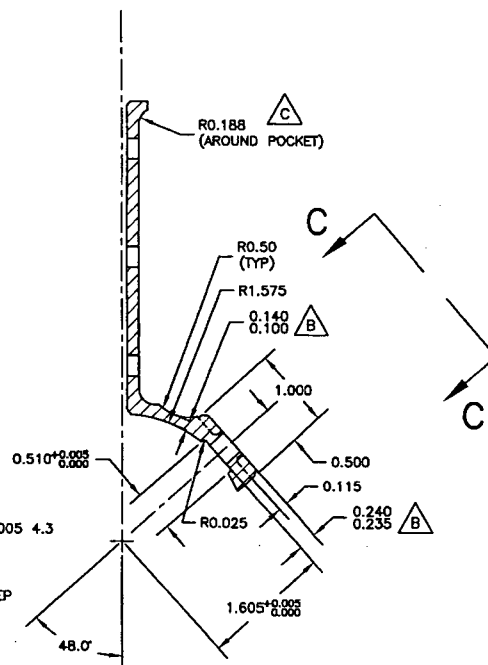


VIEW C-C

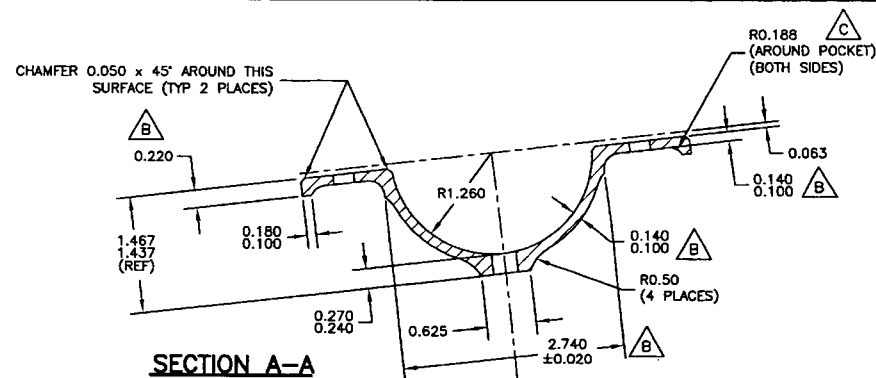
D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

NOTES:

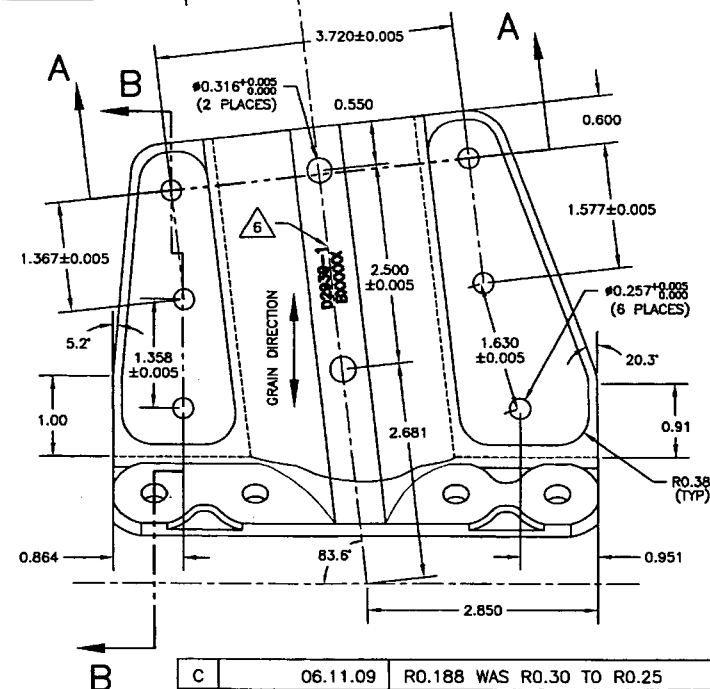
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



SECTION B-B



SECTION A-A



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	BY	DART DART AEROSPACE USA, INC.
CHECKED	APPROVED	DRAWING NO. D2939
DATE	06.11.09	TITLE SADDLE INSIDE
		REV. C SHEET 1 OF 1 SCALE 2:3

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07.02.12

